

**Work Order ID 80696****\*80696\***

Page 1

February-27-12 2:52:44 PM

Item ID: D4074-3      Accept      **\*N900040100\***      Setup Start **\*NS1\***  
Revision ID:      Stop **\*NS2\***  
Item Name: Channel  
Start Date: 27/02/2012      Start Qty: 10.00      **\*10\***      Cust Item ID:  
Required Date: 12/03/2012      Req'd Qty: 10.00      **\*10\***      Customer:  
Reference:

Approvals:      Process Plan: MLJ      Date: 12/02/27      Tooling:      Date:      Run Start **\*NR1\***  
QC:      Date:      SPC (Y/N):      Date:      Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4074	C

100      0.00

**\*100\***

Waterjet

FLOW CNC Waterjet

364.050

**Memo**

1-Cut as per Dwg

Dwg Rev: EProg Rev: E

2-Deburr if necessary

0.00

B12-3-4

110

QC2- Inspect parts off machine FAI/FAIB

0.00

**\*110\***

QC

Quality Control

**Memo**

0.00

B12-3-4

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 80696****\*80696\***

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February-27-12 2:52:44 PM

Item ID: D4074-3

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Channel

Start Date: 27/02/2012 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 12/03/2012 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals:

Process Plan: \_\_\_\_\_

Date: \_\_\_\_\_

Tooling: \_\_\_\_\_

Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_

Date: \_\_\_\_\_

SPC (Y/N): \_\_\_\_\_

Date: \_\_\_\_\_

Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00		5.7/3/15		count (X23)			
130 <b>*130*</b> Brake NC Brake NC	Bend as per dwg  Memo	0.00 0.00		Sp 12/03/106		(23)			
140 <b>*140*</b> QC Quality Control	QC5- Inspect part completeness to step on W/O  Memo	0.00 0.00		5.7/3/107		count (X23)			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

**Work Order ID 80696**

February-27-12 2:52:44 PM

**\*80696\***

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Item ID: D4074-3 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Channel  
Start Date: 27/02/2012 Start Qty: 10.00 **\*10\*** Cust Item ID:  
Required Date: 12/03/2012 Req'd Qty: 10.00 **\*10\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
150	Identify as per dwg & Stock Location: <u>120</u>	0.00							
<b>*150*</b>									
Packaging	Memo	0.00							
Packaging									
160	QC21- Final Inspection - Work Order Release	0.00							
<b>*160*</b>									
QC	Memo	0.00							
Quality Control									

12/3/12 2:52  
23

MLJ 12/03/07

MLJ 12/03/07  
23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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**NOTE:** Date & initial all entries

# Picklist Print

February-27-12 2:52:48 PM

Page 1

Work Order ID: 80696

\*80696\*

Parent Item: D4074-3

\*D4074-3\*

Parent Item Name: Channel

Start Date: 27/02/2012

Required Date: 12/03/2012

Start Qty: 10.00

Required Qty: 10.00

## Comments:

IPP Rev:A 10.06.08 new issue DD verf:EC  
AS PER ECN 11-613 11-07-25 JLM VERIFIED BY:EC

IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S18GA		Purchased		No		100	sf	284.5050	0.0316	0.332632			

\*M304S18GA\*

\*\*

AB12-3-4

304/316 .050 Sheet

## Location

## Loc Qty

## Loc Code

MAT020

284.505

119032

17.3

119383

96

119766

25.205

120243

26

120604

120

120243

# Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date		Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

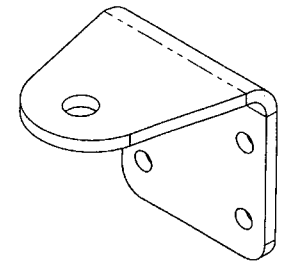
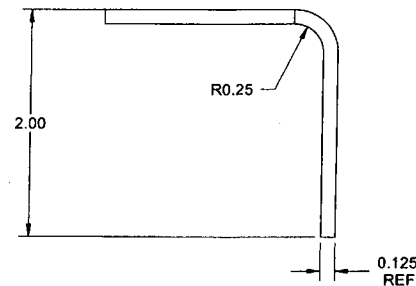
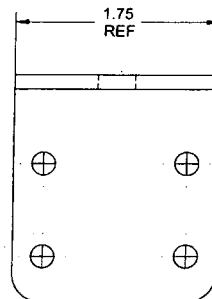
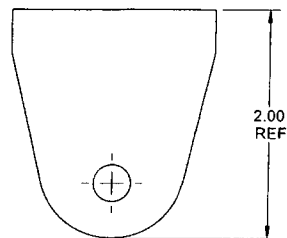
Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries







SUBMIT  
 REVISION  
 UNCONTROLLED  
 SUBMIT  
 WITH  
 NO. 8069.6-MLJ  
 12/02/27

RELEASED  
 2011-10-26

**D4074-1 BRACKET**  
 (MAKE FROM D4074-1F FLAT PATTERN)

**NOTES:**

- 1) MATERIAL: MAKE FROM D4074-1F FLAT PATTERN
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

C	MODIFY -7 STRIKER PLATE, SHEET 6 AND 7	HS	11.10.12
B	Ø 0.173 WAS Ø 0.129 (ZN B3-4); 1.28 WAS 0.90 (ZN C4-6); 1.93 WAS 1.55 (ZN C2-7); 2.10 WAS 1.72 (ZN C1-7)	RF	11.03.07
A	NEW ISSUE	HS	10.09.16
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	RF		
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D4074	SHEET 1 OF 7
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	BRACKET	NTS
DATE	11.10.12	COPYRIGHT © 2010 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

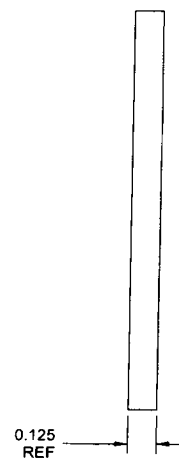
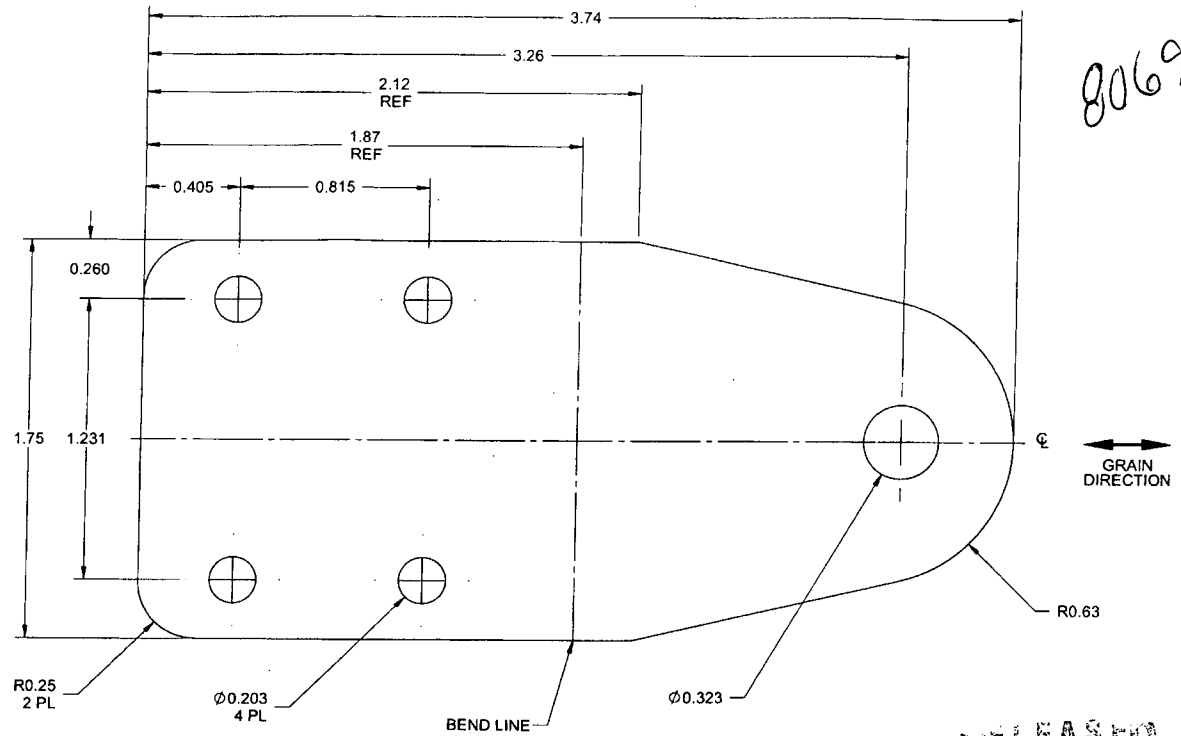
Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

80696



**D4074-1F FLAT PATTERN**

- NOTES:**  
 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK  
 PER QQ-A-250/11 OR AMS-QQ-A-250/11  
 OR AMS 4025 OR AMS 4027  
 OR ASTM B209  
 REF DART SPEC M6061T6S.125  
 2) FINISH: N/A  
 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED  
 4) UNITS: INCHES UNLESS OTHERWISE NOTED  
 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX  
 6) IDENTIFICATION: NONE  
 7) WEIGHT: 0.07 lbs  
 8) PART IS SYMMETRICAL ABOUT CENTERLINE

RELEASED  
 2011-10-26  
 AN

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	<b>D4074</b>	SHEET 2 OF 7
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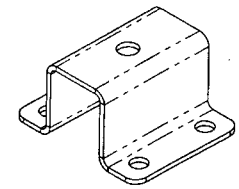
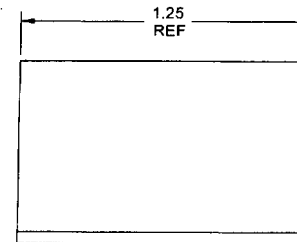
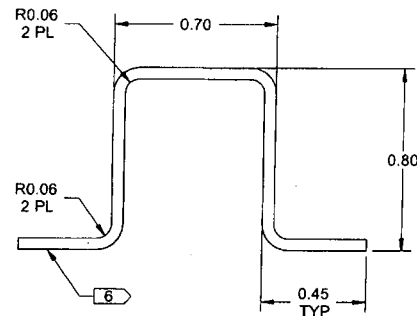
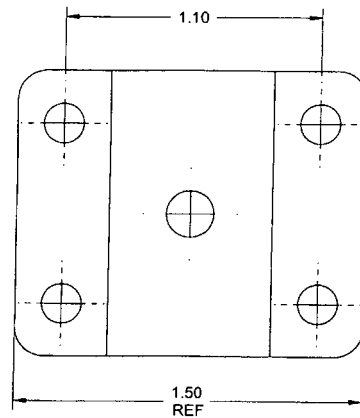
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



80696

**D4074-3 CHANNEL**  
(MAKE FROM D4074-3F FLAT PATTERN)

RELEASED  
2011-10-26

**NOTES:**

- 1) MATERIAL: MAKE FROM D4074-3F FLAT PATTERN
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.05 lbs

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D4074	SHEET 3 OF 7
APPROVED	RF	TITLE	SCALE
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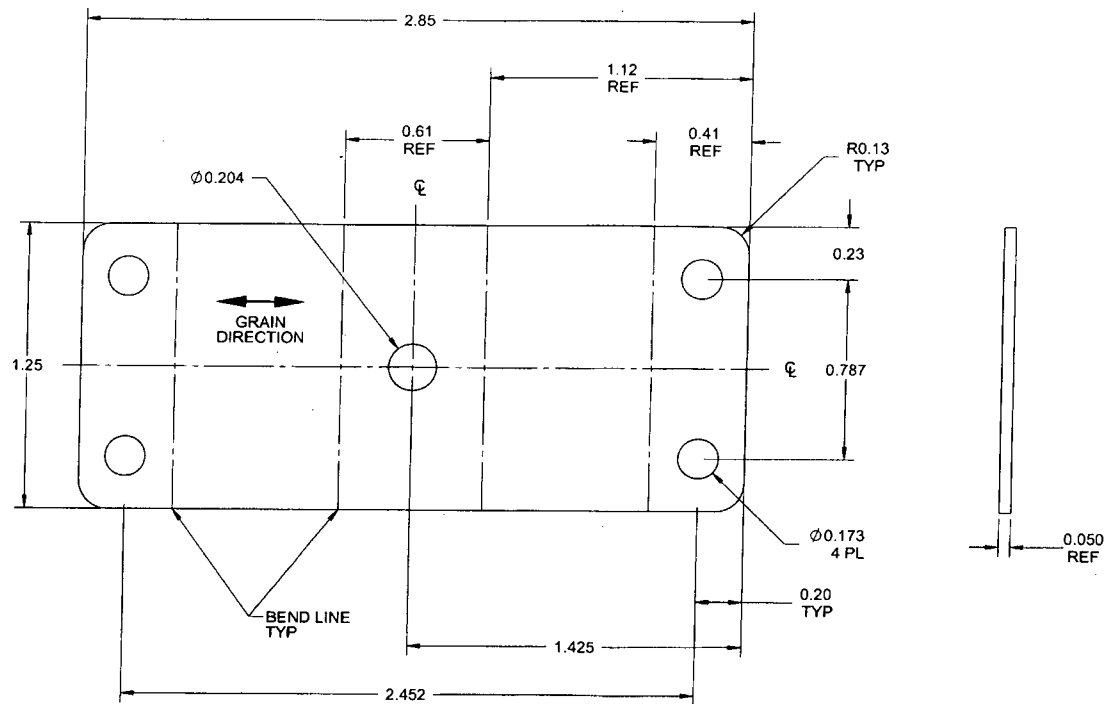
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



# NOTES:

- 1) MATERIAL: AISI 304/316 SS SHEET ANNEALED 2B FINISH  
0.050 (18 GAUGE) THICK  
OR AMS 5513 (304)  
OR AMS 5524 (316)  
OR ASTM A240  
OR ASME SA240  
REF DART SPEC M3046S18GA
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.05 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

## **D4074-3F FLAT PATTERN**

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	<b>D4074</b>	SHEET 4 OF 7
APPROVED	RF	TITLE	SCALE
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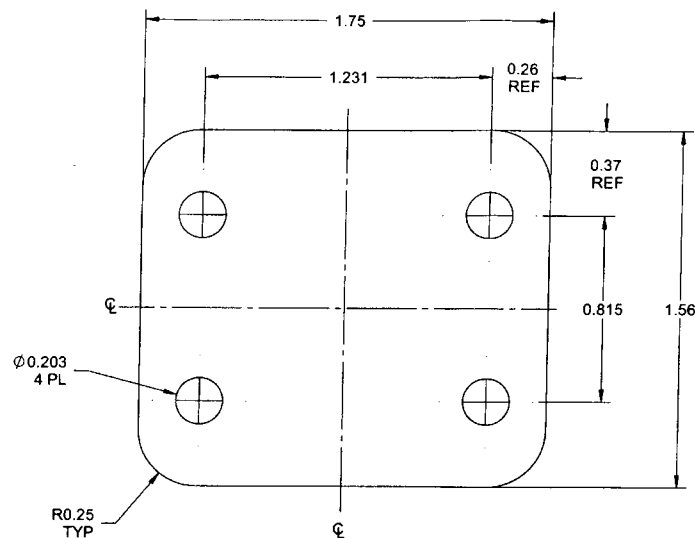
W/O:		WORK ORDER CHANGES					
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Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



**D4074-5 BACKING PLATE**

**NOTES:**

- 1) MATERIAL: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK  
PER QQ-A-250/11 OR AMS-QQ-A-250/11  
OR AMS 4025 OR AMS 4027  
OR ASTM B209  
REF DART SPEC M6061T6S.063
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.02 lbs
- 8) PART IS SYMMETRICAL ABOUT CENTERLINE

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	<b>D4074</b>	SHEET 5 OF 7
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2011-10-26

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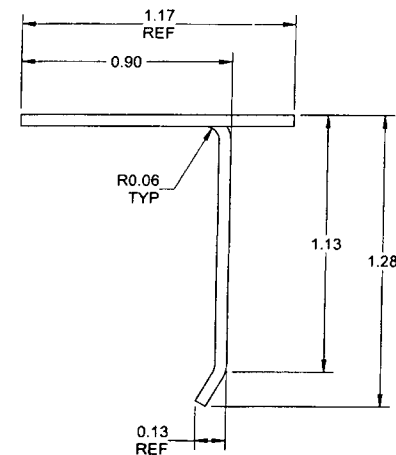
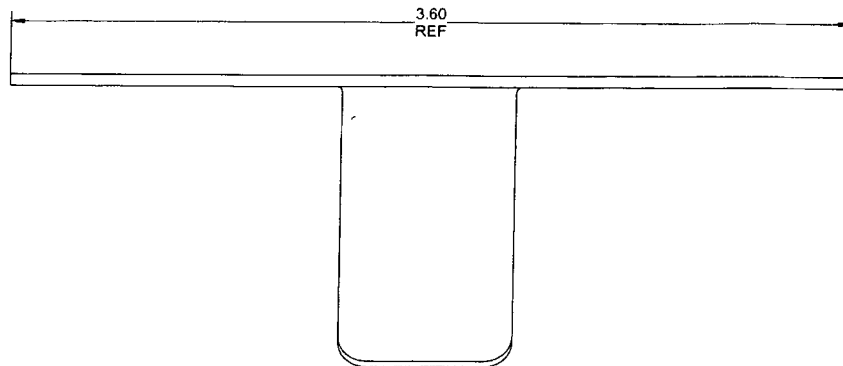
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**NOTE:** Date & initial all entries



80696

**D4074-7 STRIKER PLATE**  
(MAKE FROM D4074-7F FLAT PATTERN)

**NOTES:**

- 1) MATERIAL: MAKE FROM D4074-7F FLAT PATTERN
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: PER QSI 044 6.1
- 7) WEIGHT: 0.07 lbs

RELEASED  
2011-10-26

DESIGN	RF	<b>DART AEROSPACE USA, INC.</b>	
DRAWN	RF	KENT, WA	
CHECKED	RF	DRAWING NO.	REV. C
MFG. APPR.	RF	D4074	SHEET 6 OF 7
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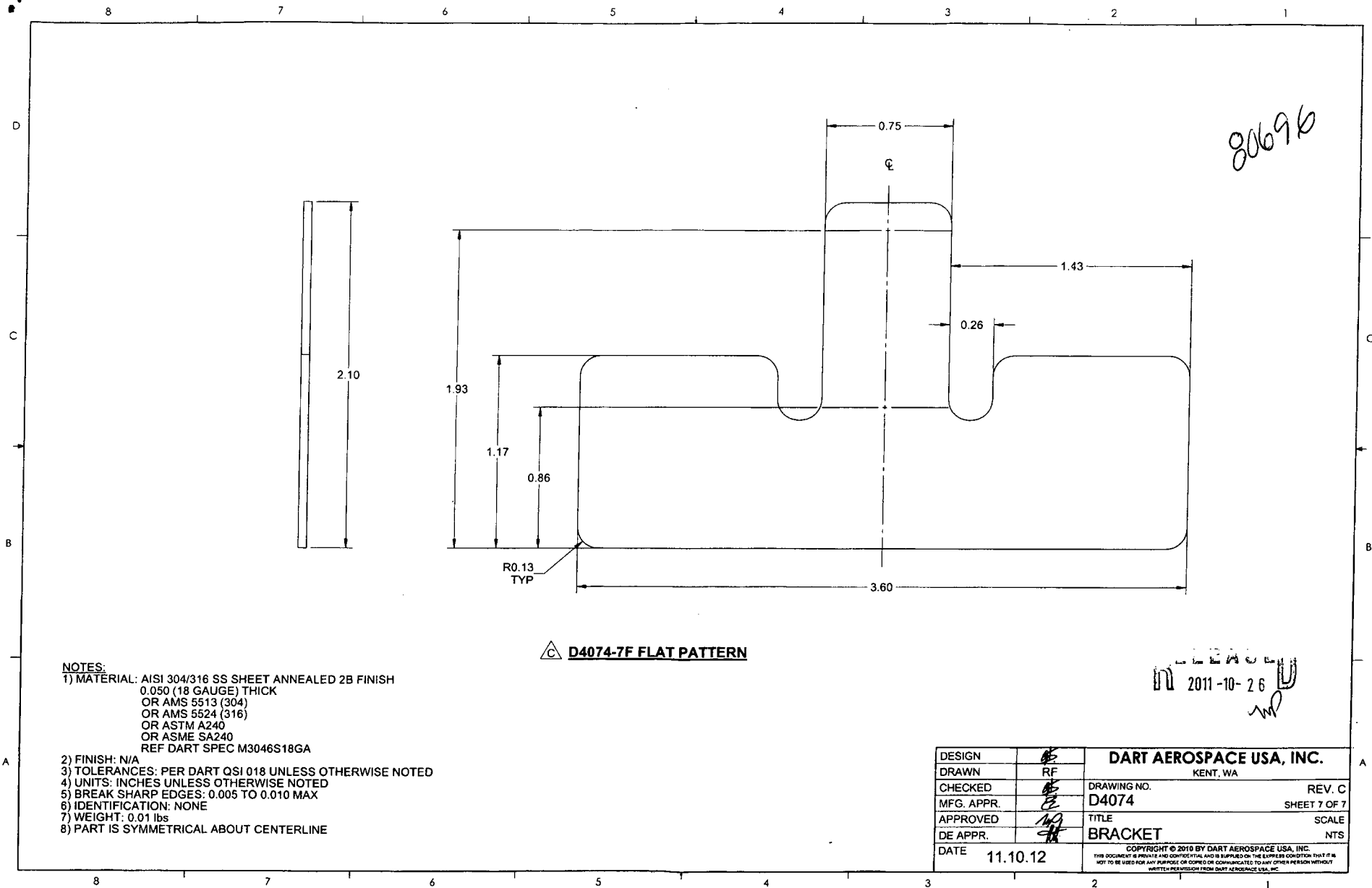
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